

Date: Thursday, 3/30/2006 8:30:26 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG ASSEMBLY		
Job Number	: 26407					
Estimate Number	: 10012					
P.O. Number	: N/A		Part Number	: D27363		
This Issue	: 3/30/2006	S.O. No. : N/A	Drawing Number	: D2736 REVA		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A	Type : LARGE FAB ASSY	Drawing Revision	: A		
Previous Run	: 25837		Material	: N/A		
Written By	: See COMMENT BELOW		Due Date	: 4/10/2006 Qty: 40 Um: Each		
Checked & Approved By	: KJ 06.03.30					
Comment	: Est Rev:D Removed from 9 digit 05-10-25 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2591	Lug	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: Qty Part Number Description Batch B25863 12 1 D2591 Lug (1) B24898 B26002 A 18 CPL 06.04.18	(40)
2.0	D27353	Lug Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: Qty Part Number Description Batch B21606A 1 D2735-3 Lug Bracket B25867 B25867 CPL 06.04.18	(40)
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 Weld D2591 & D2735-1 as per QSI 004 and Dwg D2736 using locating Jig DT8484 Steel Rod Batch: M18579	(40) CPL 06.04.18
4.0	QC5/9	WELD INSPECTION	
		Comment: WELD INSPECTION	11.06.04.19 (10)
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3	a.m 06.04.19 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 04/04/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

(06/04/20) (40)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 149

PD 06/04/20 (40)

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/04/21

Job Completion



U 06/04/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

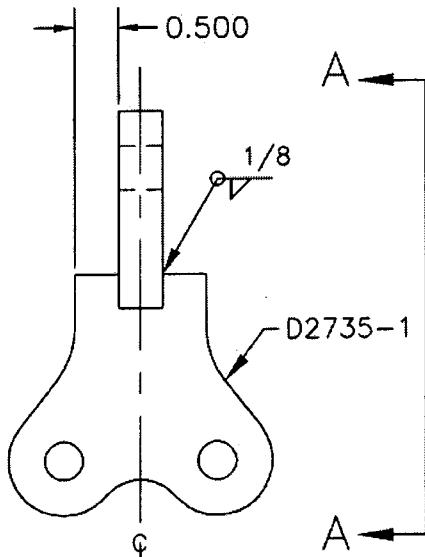
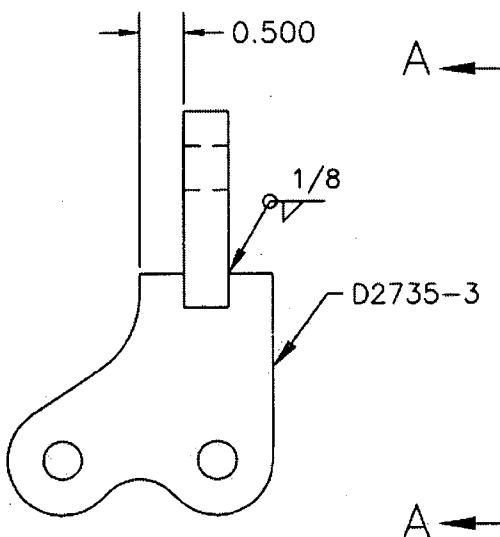
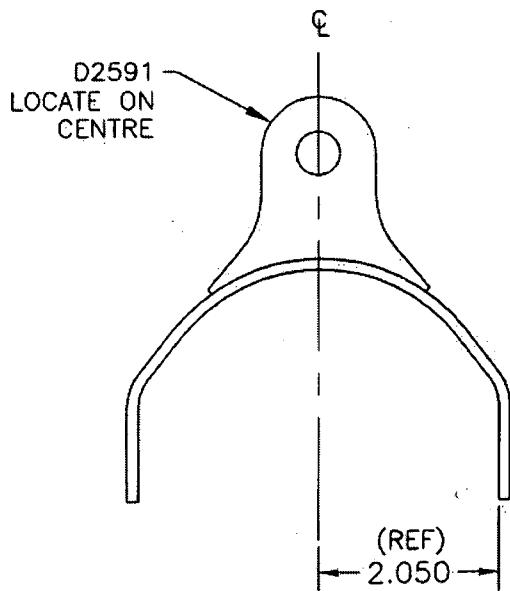
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>MW</i>	DRAWN BY <i>MW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>RE</i>	APPROVED <i>JF</i>	DRAWING NO. D2736	REV. A SHEET 1 OF 1
DATE 97.12.18		TITLE LUG ASSEMBLY	SCALE NTS
A	97.12.18	NEW ISSUE	

D2736-1 LUG ASSEMBLYD2736-3 LUG ASSEMBLYVIEW A-ANOTES:

WELD PER DART QSI 004

FINISH: POWDER COAT WHITE PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED.

PART IS SYMMETRIC ABOUT CENTRE-LINES (Q)

RELEASED
 97/12/24 DS

SHOP COPY

ECN DS7

RETURN TO

ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER
NO. 26401